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DART AEROSPACE LTD	Work Order:	20694
Description: Spacepod Hardware Kit	Part Number:	K10018
Dwg: D2174 Rev. C; D2174-041 Rev. C; D2175 Rev. C <i>RF 03.04.30</i>	Qty:	4 Kits
		Page 1 of 2

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Note: K10018 Kit to be made in multiples of 7. (1) K10018 requires (2) D2174-041. (1) D2174-041 consists of (1) D2174-1 Web & (2) D2175 Angle		04.04.13	4
2	MV	Cut blanks: (12.000" x 3.850") Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2174-1 Batch: _____			
3	MV	Cut (2) blanks per (1) K10018 Kit Cut blanks: (12.200" x 2.960") grain along 2.960 Material: 2024-T3 (QQ-A-250/5) 0.063" thick sheet (M2024T3S.063) Use stack of 7 Identify for D2175 Batch: _____			
4	MV	Machine D2174-1 as per Folio FA097 and Dwg D2174-1 Identify as D2174-1			
5	QC2	Inspect parts as they come off the CNC machine			
6	MV	Deburr for measurement			
7	QC8	Second check			
8	MV	Machine D2175 as per Folio FA083 and Dwg D2175 Identify as D2175			
9	QC2	Inspect parts as they come off the CNC machine			
10	MV	Deburr for measurement			
11	QC8	Second check			
12	GA	Deburr D2174-1 and D2175 stacks			
13	GB	Form D2175 Angle as per Dwg D2175			
14	QC5	Inspect work to Step 13			
15	FP	Chemical Conversion Coat per QSI 005 4.1 and Dwg D2174-1 and D2175			
16	QC3	Inspect work to Step 15			
17	GA	Assemble D2174-1 and D2175 as per Dwg D2174-041 Pick: <u>Qty</u> <u>Part Number</u> <u>Description</u> <u>Batch</u> 23 MS20470AD4-6 Rivet Identify as D2174-041			
18	QC5	Inspect work to Step 17			
19	FP	Powder Coat White (Ref: 4.3.5.1) as per QSI 005 4.3			
20	QC3	Inspect Powder Coat. Go to KP cell for packing.			

Dart Aerospace Ltd

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
		Initial							

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

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		Page 2 of 2

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21	KP	Pick: Packing Kit (Note: D2174-041 is not on the BOM, but is in as material from steps 2 & 3) <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2 ✓</td> <td>D2174-041</td> <td>Web Assembly</td> <td>B16562/B13738/B13732</td> </tr> <tr> <td>1 ✓</td> <td>D2985</td> <td>Decal</td> <td>B14160</td> </tr> <tr> <td>8 ✓</td> <td>A3235-020-935</td> <td>Washer</td> <td></td> </tr> <tr> <td>16 ✓</td> <td>AKS7-1032-130</td> <td>Insert(AKS7-1032-130)</td> <td>M14240</td> </tr> <tr> <td>8 ✓</td> <td>AN3-3A</td> <td>Bolt</td> <td>M4824</td> </tr> <tr> <td>8 ✓</td> <td>AN3H4A ✓</td> <td>Bolt (or AN3H4)</td> <td>M4149</td> </tr> <tr> <td>36 ✓</td> <td>AN525-10R7</td> <td>Screw</td> <td>M14940 / M14603</td> </tr> <tr> <td>8 ✓</td> <td>AN960JD10</td> <td>Washer</td> <td>M13719</td> </tr> <tr> <td>16 ✓</td> <td>AN960JD10L</td> <td>Washer</td> <td>M14312</td> </tr> <tr> <td>16 ✓</td> <td>MS21042L3 ✓</td> <td>Nut (or -3)</td> <td>M14393 / M14478</td> </tr> <tr> <td>8 ✓</td> <td>MS24694S67</td> <td>Screw</td> <td>M19750</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2 ✓	D2174-041	Web Assembly	B16562/B13738/B13732	1 ✓	D2985	Decal	B14160	8 ✓	A3235-020-935	Washer		16 ✓	AKS7-1032-130	Insert(AKS7-1032-130)	M14240	8 ✓	AN3-3A	Bolt	M4824	8 ✓	AN3H4A ✓	Bolt (or AN3H4)	M4149	36 ✓	AN525-10R7	Screw	M14940 / M14603	8 ✓	AN960JD10	Washer	M13719	16 ✓	AN960JD10L	Washer	M14312	16 ✓	MS21042L3 ✓	Nut (or -3)	M14393 / M14478	8 ✓	MS24694S67	Screw	M19750			
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22	QC4	Inspect Kit 100% for Completeness on the W/O		04/05/04	4																																																
23	ST	Identify and Stock		04/05/04	4																																																
24	AC	Cost / part 62.02		04-08-05	4																																																
25	DC	Close W/O 62.02 Inspect Level 21		04.05.05	4																																																

Rev	Date	Change	Revised By	Approved
A	03.03.26	New issue	KJ/RF	#

RELEASED
03.04.30 #

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
		Initial							

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2004
03:42 pm

Work Order No	:	0020694	Department Code:	
Project Name	:	K10018	Burden Flags	: NNNNNNN
Project For	:	WK418	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	K10018	Invoice Number	:
Description	:	Spacepod Hardware Kit	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	4	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	04-12-04	Est Margin	: 0.000%
Est Finish Date	:	04-30-04	Actual Margin	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
<hr/>					
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00